Work Order ID 86195 *86195* Page 1 June-22-12 1:56:00 PM Item ID: D2275 Accept Setup Start *N900040100* Revision ID: Item Name: Bushing **Start Date: Start Qty: 20.00** 22/06/2012 **Cust Item ID:** - Required Date: 06/07/2012 Req'd Qty: 20.00 **Customer:** Reference: Run Process Plan: MLJ Date: 12 06 27 Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Plan Set Up/ Tool ID Tool # Reject Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp **Draw Nbr Revision Nbr** D2275 Rev C 100 0.00 2 2.30 20 Hardinge CNC LATHE SMALL *100* Hardinge 0.00 Memo Hardinge CNC Lathe Small Machine as per Folio FA 213 Tumble & deburr all sharp edges 110 QC2- Inspect parts off machine FAI/FAIB 0.00 < *110* 12. 12. 36 QC 0.00 Memo Quality Control

QC8- Inspect parts - second check 0.00 *120* QC 0.00 Memo Quality Control

120

(/c// 13.01.02 20

Dart	Aeros	pace	Ltd
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W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: E								
	Re	esolution:	Disposition	n: '	QA: N/C CI	osed:		Date: _					
NCR:		,	WORK ORDI	ER NON-CONFORMA	NCE (NCF	R)							
DATE	STEP	Description of NC		n B		cation	Approval	Approval					
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector				
		,											

June-22-12 1:56:00 PM Item ID: D2275 Accept *N900040100* Setup Start **Revision ID:** Item Name: Bushing **Start Qty: 20.00** *20* Start Date: 22/06/2012 **Cust Item ID: Required Date:** 06/07/2012 Req'd Qty: 20.00 **Customer:** Reference: Run Start Approvals: Process Plan: Date: **Tooling:** Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Reject Reject Accept Insp. **Work Center ID** Description **Run Hours** Qty Code Stamp **Qty** Number Identify as per dwg & Stock Location: 130 0.00 *130* Packaging 0.00 Memo Packaging *** STOCK IN STEP CELL*** 140 QC21- Final Inspection - Work Order Release 0.00 QC 0.00 Memo Quality Control

U 13-01.03

W/O:			WO	RK ORDER CHANG	GES							
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector			
			, , , , , , , , , , , , , , , , , , , ,									
Part No):	PAR #:	Fault Categ	ory:	NCR: Yes	s No DQ	A:	Date:				
	Res	solution:	Disposition	:	QA: N/C	Closed:						
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)						
DATE	STEP	Description of NC			ction B		cation	Approval	Approval			
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		ion C	Chief Eng	QC inspector			
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Picklist Print

June-22-12 1:56:03 PM

Work Order ID: 86195

D2275

Parent Item Name: Bushing

86195

D2275

Start Date: 22/06/2012

Required Date: 06/07/2012

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

Parent Item:

IPP E02.03.27Added in house machiningNG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.250		Purchased	No			100	f	25.6600	0.1667	3.509474			
M6061T6R1 250									**				

M6061T6R1 250

6061-T6 Round Bar 1.250

Location Loc Qty Loc Code MAT013 25.66 5.66 20

		— - - -												
W/O:			WC	RK ORDER CHANG	ES									
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
								1						
		PAR #:	PAR #: Fault Category:					NCR: Yes No DQA: Date						
Resolution:		esolution:	Disposition	n; <u></u>	QA:	N/C Clo	sed:		Date: _					
NCR:		,	WORK ORDI	ER NON-CONFORM	ANCE	(NCR)							
DATE	STEP	Description of NC	Corrective Action Section Initial Action Description			Sign &	Verific			Approval				
		Section A	Chief Eng	Action Description Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector				
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DART AEROSPACE LTD	Work Order:	86195
Description: Bushing	Part Number:	D2275
Inspection Dwg: D2275 Rev: C		Page 1 of 1

	FIRS	T ARTICLE IN	NSPECTI	ON CHE	ECKLIST		
	x	First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o		mments
1.975	+/-0.010	1.982		٦.	SQ. 2		
1.500	+/-0.010	1.508					
Ø0.750	+0.008/-0.001	. 756					
0.10 x 45°	+0.030 x 0.5°	10					
Ø0.257	+0.006/-0.001	,258		-			
1.25	+/-0.030	1-2-13					
			-				
, 10 (April 14)	(nAc						
easured by:	() 4 9-83	Audited by:	Carl	/-	Prototype /	Approval:	N/A
Date:	12.2.30	Date:	13:01.	0>		Date:	N/A
ev Date	Change		77-			Revised by	Approve
06.09.19	New Issue			*		KJ/JLM	- 7/1

W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No:		PAR #:	Fault Categ	NC	R: Yes	No DQA	.:							
Resolution:		esolution:	Disposition		QA	: N/C (closed:		Date: _					
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NC	R)							
DATE	STEP	Description of NC	Corrective Action Section				Verific	ation	Approval	Approval				
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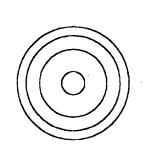
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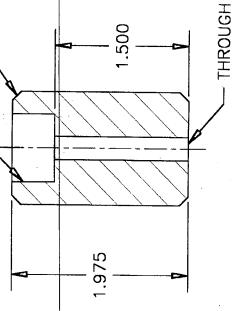
		—			٠		
S		REV. C	SHEET 1 OF 1	SCALE	1:1		
DART AERO ACCESSORIES INC	VICTORIA INTERNATIONAL AIRPORT, CANADA		D2275 SHEET	TILE	BUSHING	Nov. 15, 1994 C'BORE WAS COUNTER SINK	96.09.12 C'BORE WAS 0.300 DEEP
G)	B. Williams	RAY APPROVED			Sep. 29, 1994	Nov. 15, 1994	96.09.12
PREPARED	B			DATE	Sep.	В	ပ

BELEASE



SHOP COPY **RETURN TO**

CBORE &0.75 CBORE



0.257

STOCK BAR 25 6061-T6 MATERIAL:

Copyright 1994 by DART AERO ACCESSORIES INC

Dait Aci	oopaoc	Liu		•											
W/O:			WORK ORDER CHANGES												
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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		PAR #:													
	R	esolution:	Disposit	ion:	QA	: NC CI	osed:		Date:						
NCR:		V	VORK OR	DER NON-CONFORM	IANCE	(NCR	(1)								
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	ction B	Sign &			Approval Chief Eng	Approval QC Inspector					
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